

Date:
User:Monday 1/14/2008 2:37:00 PM
Kim Johnston

Process Sheet

SPIT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG
 Job Number : 36747-4
 Estimate Number : 10255
 P.O. Number :
 This Issue : 1/14/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : MACHINED PARTS
 Previous Run : 36102
 Part Number : D22301
 Drawing Number : D2230 REV F
 Project Number : N/A
 Drawing Revision : F
 Material :
 Due Date : 2/15/2008 Qty: 200 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est D 80.11.01 Added inspection level 8, and removed P/O for powder coat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s)

Lug Extrusion D2423 Extrusion

Batch: 133310

c20810115

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 extrusion to 0.82"

Batch:

cut at Metec

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2230-1

(Check for crack while loading into the machine.)

2-Tumble and deburr rough edges after tumbling

Issue PD 5448

Machine per ~~folio~~ drawing D2230 REV F

c20810115

4.0 Q22 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ensure 1 of C attached / 1 8-40 (80)

5.0 Q25 SECOND CHECK



Comment: SECOND CHECK inspect level 5

counts
5 0810109 x80

.e: Monday, 1/14/2008 2:37:01 PM
.ser: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 36747

Part Number: D22301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/02/05 (80)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FL 08/02/05 (80)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M106379

M-FL 08/02/05

(80X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DS - FL

08-02-05

(80X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST476

DS 05/02/11

(X80)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

080213

Job Completion

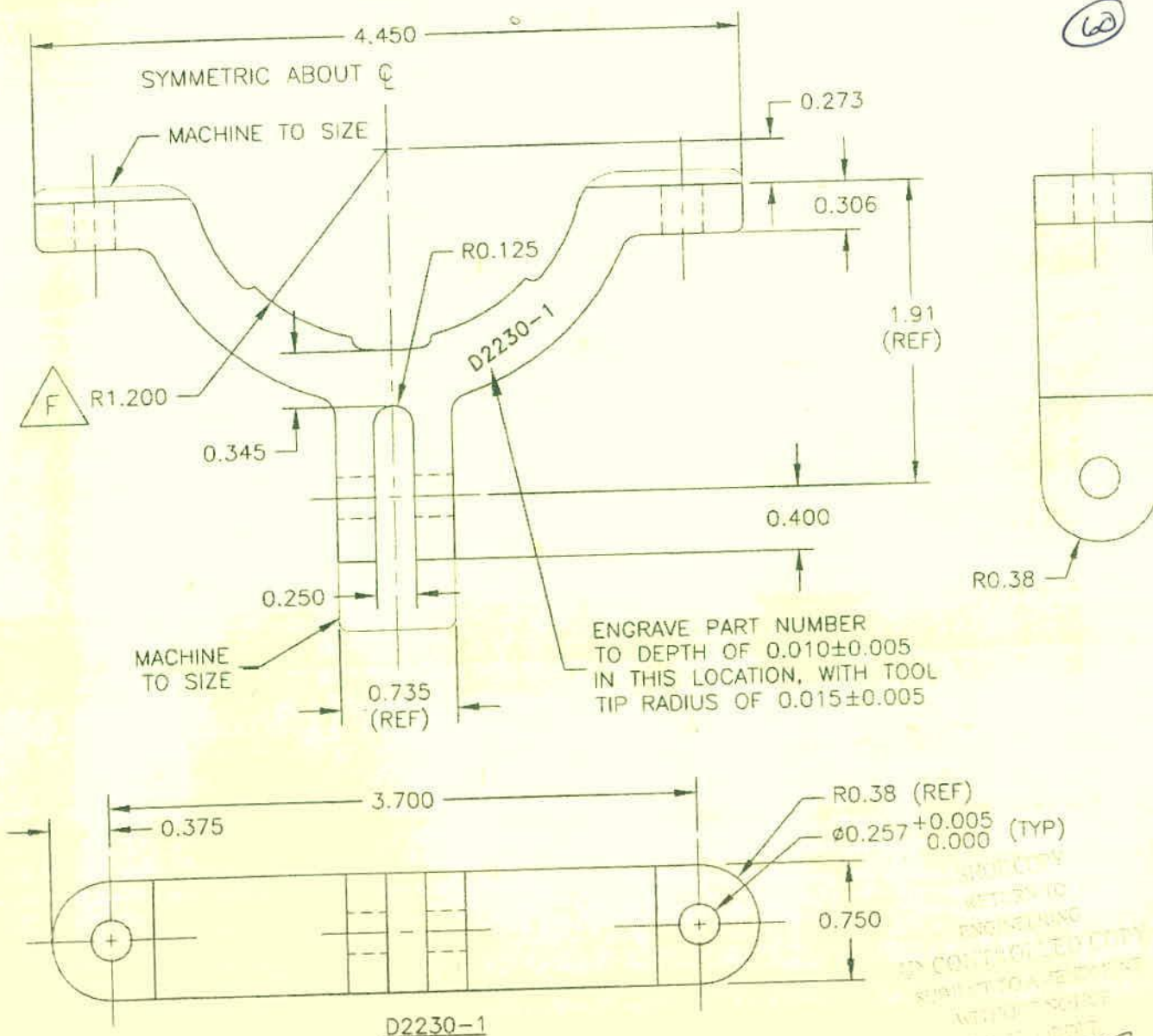


2008/2/11 (80)
W



DESIGN <i>CP</i>		DRAWN BY <i>CP</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>		APPROVED <i>[Signature]</i>		DRAWING NO. D2230	
				REV. F SHEET 1 OF 2	
DATE 99.12.13		TITLE MOUNTING LUG		SCALE 1:1	
C	94.03.30	RE-DESIGN			
D	95.01.04	RE-DESIGN			
E	95.01.04	RE-DESIGN			
F	99.12.13	REDESIGN; R1.200 WAS R1.100			

RELEASED
1972 20 00



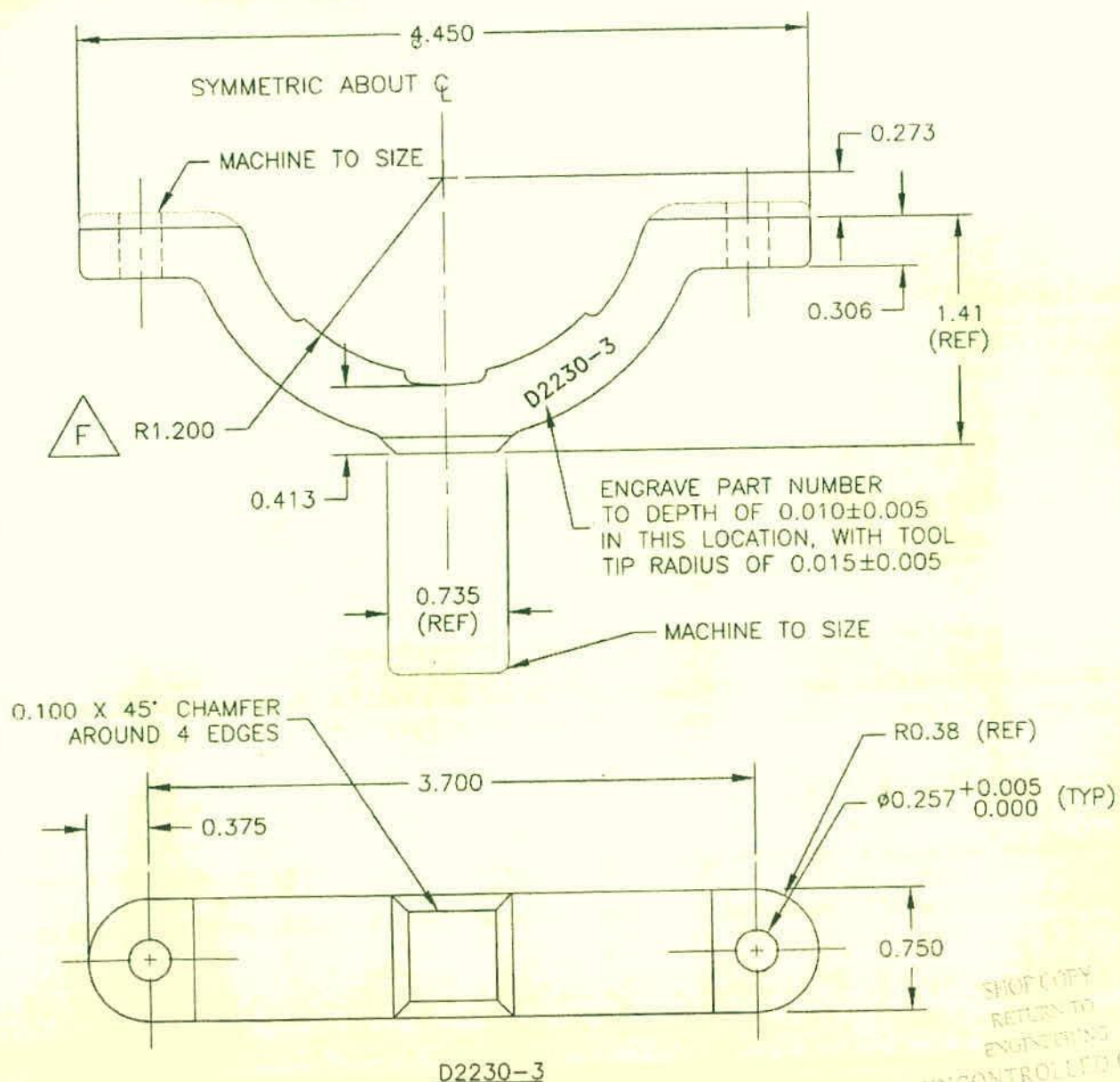
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

36747



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV.
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	SHEET 2 OF
DATE 99.12.13		TITLE MOUNTING LUG	SCALE

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 3674



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

80

D2230-1

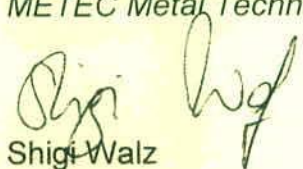
Lug B36747

P5448

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, February 1, 2008

